

Date: Wednesday, 6/28/2006 10:14:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 27713
 Estimate Number : 12464
 P.O. Number : N/A Part Number : D35087
 This Issue : 6/28/2006 S.O. No. : N/A Drawing Number : D3508 PREL
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : PREL
 Previous Run : N/A Material : N/A
 Due Date : 7/5/2006 Qty: 2 Um: Each
 Written By : See comment below
 Checked & Approved By : 06-06-28
 Comment : Est Rev: New Issue 06-06-20 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.3272 sf(s)/Unit Total : 0.6544 sf(s)
 1010/1025/A21/6aA SHEET
 (M1010S20GA)
 Batch: M100473

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: Prel
 Prog Rev: Prel

2-Deburr if necessary

SAD 06:06:29 (2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:06:29 (2)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06-07-03 (2)

5.0 BRAKE NC NC BRAKE




Comment: NC BRAKE pt 8326
 1-Form on brake using DT8178 and DT8261 as per Dwg D3508

06/07/04 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 26/07/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 10:14:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27713

Part Number: D35087

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



John 7-04 (2)

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FE 06 07 08 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

G.M. 06-07-05

(2) ~~(2)~~

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: */ -*

PC 6/8/6 (2)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/07 (2)
[Signature]

Job Completion



Dale
Return to PH
Guil
U 06-08-07

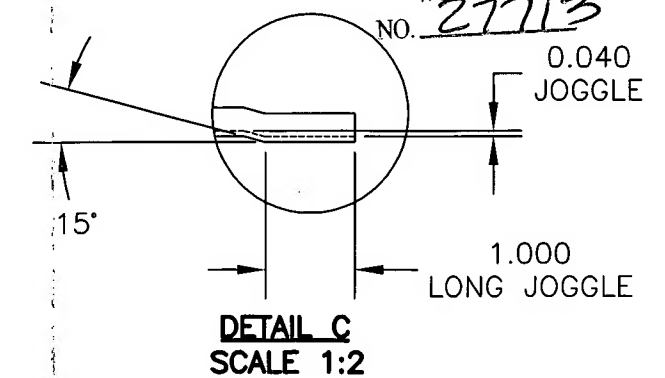
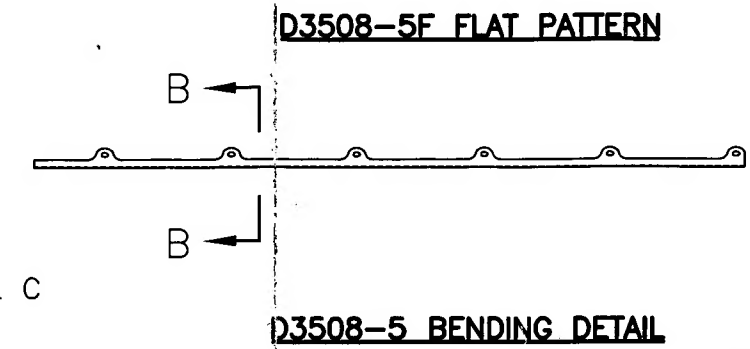
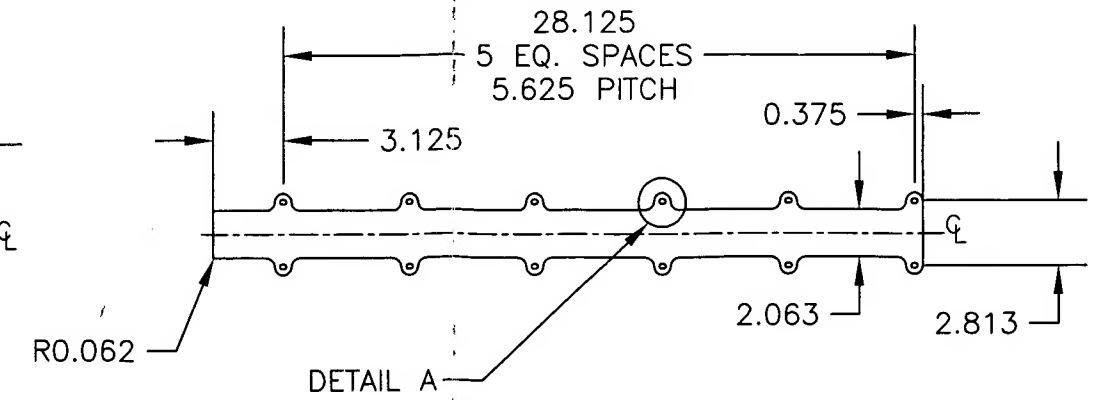
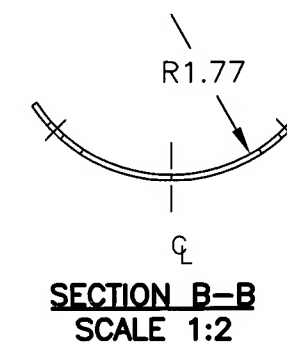
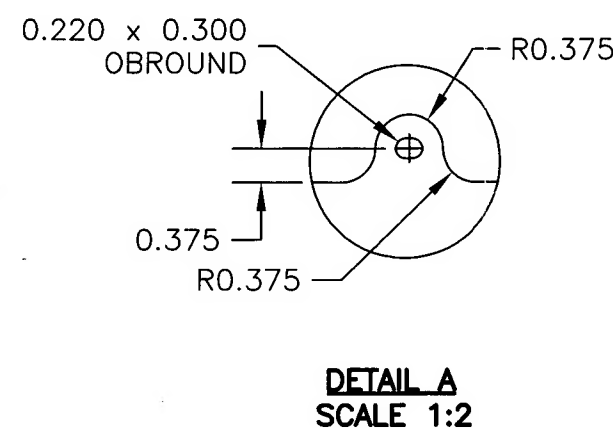
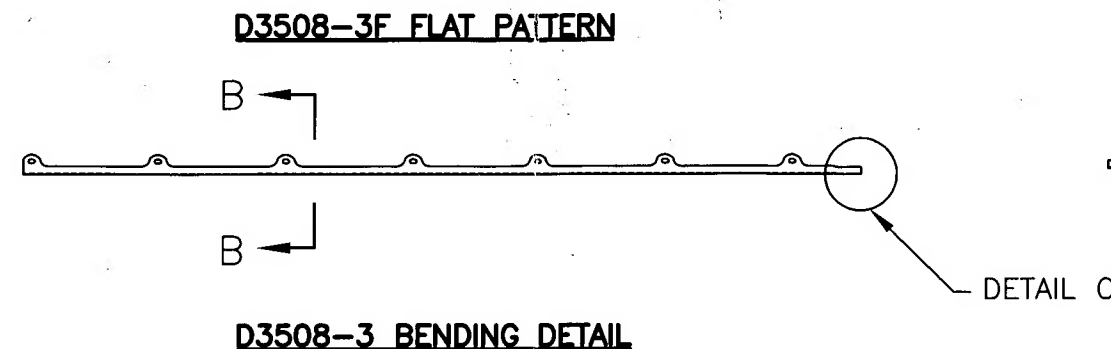
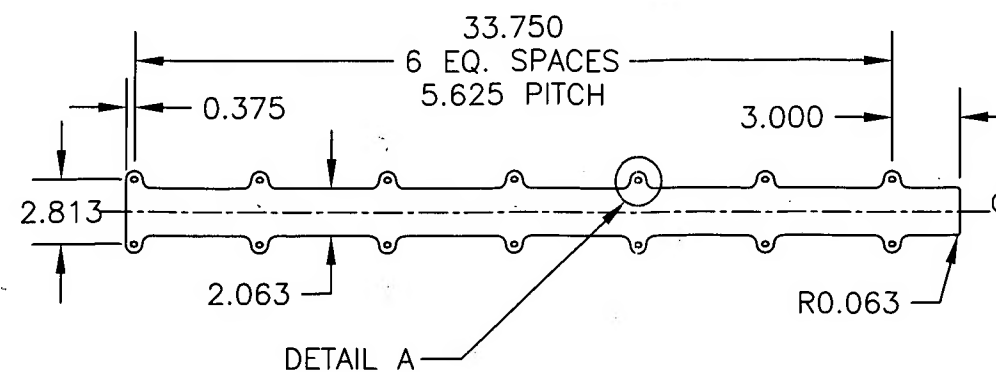
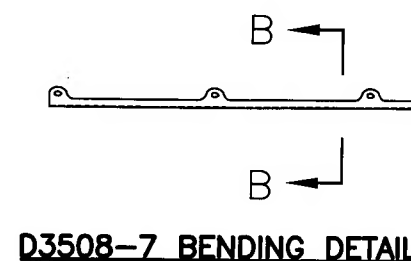
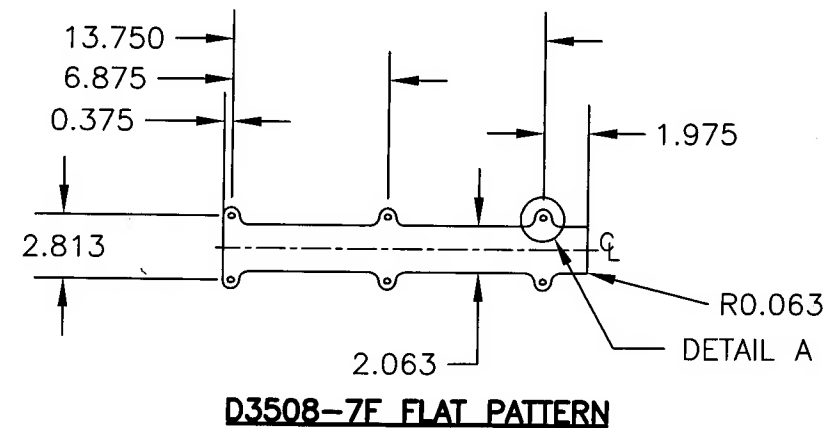
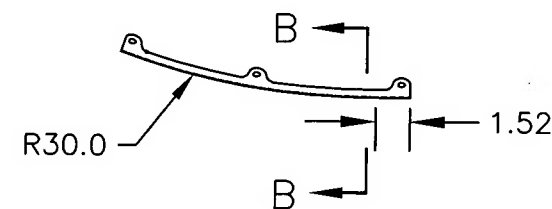
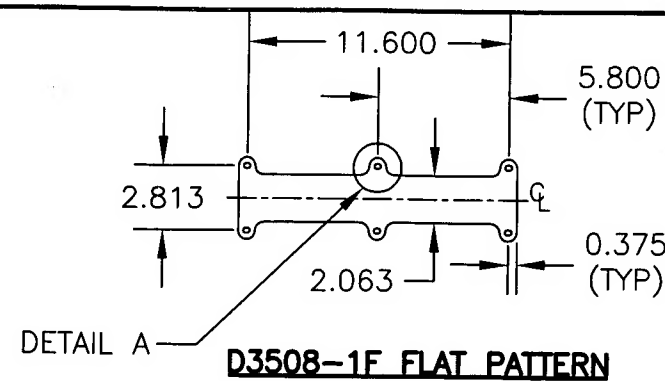
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27713


PRELIMINARY ISSUE

D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK) (REF DART MATERIAL SPEC M1010-S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.		06.04.21		NEW ISSUE	
DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO. D3508	REV. A SHEET 1 OF 1
DATE	06.04.21	TITLE WEARPLATE		SCALE 1:1	

m100473

 SIDERURSA DEL ORINOCO S.A. MATANZAS - VENEZUELA		CERTIFICADO DE CALIDAD / MILL TEST CERTIFICATE		PAGINA: 01-A Nº DE CERTIFICADO: 04210437 ID: 28925																
CS U L I D E D E C T E D O		D E M O N T R E A L , C A N A D A		O C M P R A - P u r c h a s e O r d . N º * O R E N T A - R N - S i d e O r d . N º D E S P A C H O - S h i p p e r N º F A C T U R A - I n v o i c e N º V E H I C U L O - V e h i c l e																
TECHINTRADE CORP. 2200 WEST LOOP SOUTH, SUITE 750 HOUSTON, TEXAS 77027.		SA98616 -07 01 09 04 11 11 04 LOTE: L0001		IDA																
PRODUCTO Prime Newly Produced Cold Product SAMUEL. SON & CO J15000 /		ROLLED STEEL COILS TECHINTRADE S.O. 100000217		ASTM A 1008 CS TIPO-B																
DIMENSIONES Dimensions		COLOUR MARK SIZE 0.0530 MIN X 48.000		TIPO DE ANALISIS Analysis Type HEAT PHYSICAL TEST																
PHYSICAL TEST		CHEMICAL COMPOSITION - %																		
Nº COLADA Heat Nº	Nº DE MUESTRA Sample Identification	TRACCION			DRZ	DOB	C	MN	P	S	SI	CU	AL	MO	NB	V	NI	CR	B	
		ESF Y.P	ESF UTS	% AL	-1	-2	-2	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-4
		MFA	MFA	002P	X10	180	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10
					HRB	GRAD														
		MIN.	1.00	2.00	1.00		2						20							
		MAX.				400	15	60	30	35	100	200	80	60	8	8	200	150	10	
243097			214.00	312.00	40.00	490	OK	005	028	010	004	023	010	029	004	001	001	011	013	000
544031			215.00	336.00	38.00	500	OK	006	028	009	004	064	002	029	002	001	001	003	006	001
644146			187.00	274.00	38.00	580	OK	007	033	009	001	032	007	023	002	001	001	005	009	000

C4374B

OBSERVACIONES / NOTE

SIDERURSA DEL ORINOCO S.A.
 Gerencia de Gestión de Ordenes
 as issuing agent